



<b>IMH-LM-1500</b>	<b>IMH-LM-2000</b>	<b>IMH-LM-3000</b>
<p><b>Machine specification</b></p> <p>Leg board magazine 1 pcs            Block pushers 3 pcs            Nail boxes 1 pcs            Individual nailers 6 pcs            Minimum ceiling height: 4 400 mm</p> <p><b>Dimension of material</b></p> <p><b>Leg boards:</b></p> <p>Tickness 12-35 mm            Width 75-145 mm            Length 600-1500 mm</p> <p><b>Blocks:</b></p> <p>Height 75-100 mm            Width 75-145 mm            Length 75-145 mm</p> <p><b>Performance</b></p> <p>Change over time 3-15 minutes            Legs &lt; 1400 mm 12 legs / min            Wings 0-100* mm</p>	<p><b>Machine specification</b></p> <p>Leg board magazine 1 pcs            Block pushers 3 pcs            Nail boxes 1 pcs            Individual nailers 6 pcs            Minimum ceiling height: 4 400 mm</p> <p><b>Dimension of material</b></p> <p><b>Leg boards:</b></p> <p>Tickness 12-35 mm            Width 75-145 mm            Length 600-2000 mm</p> <p><b>Blocks:</b></p> <p>Height 75-100 mm            Width 75-145 mm            Length 75-145 mm</p> <p><b>Performance</b></p> <p>Change over time 3-15 minutes            Legs &lt; 1400 mm 12 legs / min            Legs = 2000 mm 10 legs / min            Wings 0-100* mm</p>	<p><b>Machine specification</b></p> <p>Leg board magazine 1 pcs            Block pushers 3 pcs            Nail boxes 1 pcs            Individual nailers 6 pcs            Minimum ceiling height: 4 400 mm</p> <p><b>Dimension of material</b></p> <p><b>Leg boards:</b></p> <p>Tickness 12-35 mm            Width 75-145 mm            Length 600-3000 mm</p> <p><b>Blocks:</b></p> <p>Height 75-100 mm            Width 75-145 mm            Length 75-145 mm</p> <p><b>Performance</b></p> <p>Change over time 3-15 minutes            Legs &lt; 1400 mm 12 legs / min            Legs = 3000 mm 8 legs / min            Wings 0-100* mm</p>

\*In the length of the over boards. Other dimensions of wings, contact IMH.

## Usage

Production of wooden legs for 4-way pallets.

## Function

The machine joins together blocks and leg boards to make complete legs. The blocks are individually fed and positioned by an individual feeder, belt conveyor and stop-flags behind the machine.

After being positioned at the stop flags, the leg boards are released from the leg board magazine. Then the blocks and leg board are pushed from behind into the nailing position with the same pusher. The finished legs are pushed forward by the next leg behind. Release function of boards from the leg board magazine and nail picking are pneumatic. All other operations, incl. individual nailers, are hydraulic and the machine has its own hydraulic unit. The machine is controlled and monitored by its own PLC via an operator's panel.



### Nail dimensions

IMH nail boxes can handle following nail dimensions. Each ordered nailbox will be set for one selected nail dimension.

Diameter	2.1 - 4.2 mm
Length	40 - 100 mm
Quality	Machinery

### Electrical connections

Voltage	3 Phase 400 V 50 Hz
Main fuses	3 x 25 Ampere / Delay Action

### Air consumption

System pressure	6-10 bar
Nominal working pressure	6-7 bar
Consumption at 100% capacity	450 L / min

### Operators side

To the right of the machine when looking in the production flow. The machine can be constructed to have the operator on the left side if needed.

### Options

#### Products

#### Remarks

#### Single drive (1 x drive)

Extended platform	<i>Nail storage</i>
Extra nail box + fast change over	<i>Standard 1 pcs</i>
Extra nailers	<i>Standard 6 pcs, max 12 pcs</i>
Block magazine	
4 block pushers	<i>Standard 3 pcs</i>
5 block pushers	<i>Standard 3 pcs</i>
Pallet outfeed puller	

#### Double drive (2 x drive) (a totally other layout compared to 1 x drive):

Extended platform	
Extra nail box + fast change over	
Extra nailers	
Block magazine	
4 block pushers + channels	<i>Standard 3 pcs</i>
5 block pushers + channels	<i>Standard 3 pcs</i>
2 x drive, 3 block channels	
2 x drive, 4 block channels	
2 x drive, 5 block channels	
Automated change over system per system	
Automated side feeding bottom boards	
Extra leg board magazine	<i>Standard 2 pcs</i>
Pallet outfeed puller	